

Work Order ID 74442

Thursday, September 29, 2011 2:42:42 PM



Page 1

Item ID:	D2594-1	Accept		Setup	Start	
Revision ID:					Stop	
Item Name:	Plug, 205 Skidtube					
Start Date:	9/29/2011	Start Qty:	300.00		Cust Item ID:	
Required Date:	10/14/2011	Req'd Qty:	300.00		Customer:	
Reference:						

Approvals:	Process Plan: <u>M.L.J</u>	Date: <u>9/29/11</u>	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D2594	Rev C

100		0.00							
	Hardinge CNC LATHE SMALL								
Hardinge	Memo	0.00	SL	RR					
Hardinge CNC Lathe Small	1-Make as per Dwg D2594-1 and Folio FA262. 2-Break all sharp edges 0.010 max.			11/10/03				246	

110		0.00							
	QC2- Inspect parts off machine FAI/FAIB								
QC	Memo	0.00	SL	RR					
Quality Control				11/10/03				246	

120		0.00							
	QC8- Inspect parts - second check								
QC	Memo	0.00	SL	RR					
Quality Control				11/10/04				246	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Item ID: D2594-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Plug, 205 Skidtube

Start Date: 9/29/2011 Start Qty: 300.00



Cust Item ID:

Required Date: 10/14/2011 Req'd Qty: 300.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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130

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

Hand Finishing

246XØ M-L 11/10/04

140

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00



Powdercoat

Memo

0.00

Powder Coating

START TIME:

FINISH TIME:

OVEN TEMPERATURE:

11:15

320°F

11:45

246XØ M-L 11/10/06

150

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

246
COUNTED

M 118439

W/O:		WORK ORDER CHANGES					
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(b) (7)(C), (b) (7)(D)

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Accept

[illegible]

Setup Start

Stop

[illegible]**Cust Item ID:**[illegible]

Customer:

Reference:

Run Start

Stop

Operation Description

Set Up/ Run Hours

Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp

Identify as per dwg & Stock Location: FRH 0.00

1. The first step is to identify the key components of the system. This includes understanding the hardware, software, and data involved.

Packaging

Memo

0.00

Packaging

QC21- Final Inspection - Work Order Release

0.00

[illegible]

QC

Memo

0.00

Quality Control

276 ~~X~~ M-11/10/06

11/10/11 JJ
MF 11-10-7

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Picklist Print

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Page 1

Work Order ID: 74442



Parent Item: D2594-1



Parent Item Name: Plug, 205 Skidtube

Start Date: 9/29/2011

Required Date: 10/14/2011

Start Qty: 300.00

Required Qty: 300.00

Comments: IPP D 02.08.22 Make in Cobra KJ
IPP E 06.12.11 ecn 836 EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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M6061T6R0.625

Purchased

No

110

f

19.1800

0.0521

16.45263



Re 11-10-3

6061-T6 Round Bar .625"

Location

Loc Qty

Loc Code

MAT012

19.18

M117284

9.09

M117481

10.09

4.24

~~10.950~~

10.09

16.950
total

14.32

M6061T6R0.625
M117284

M6061T6R0.625
M117481

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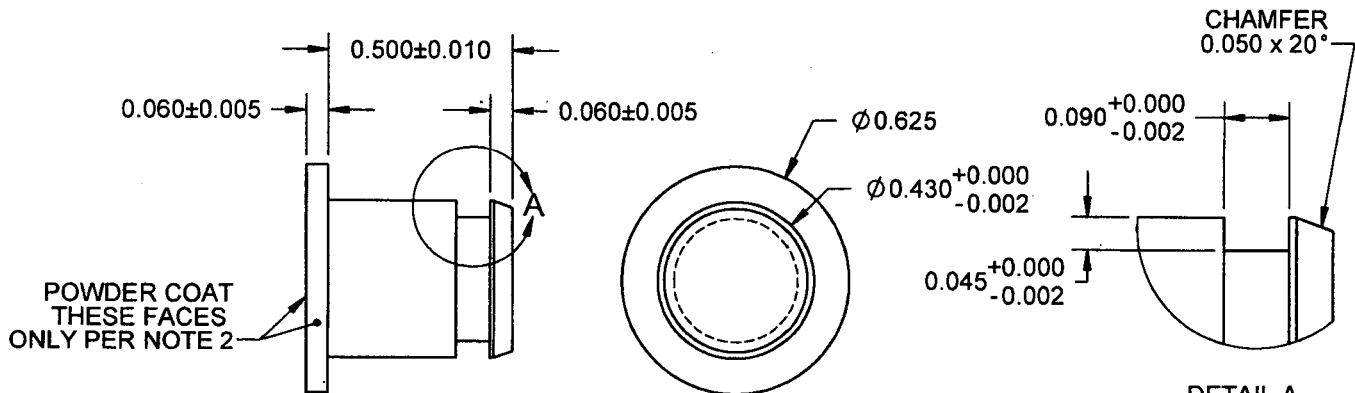
NOTE: Date & initial all entries

DART

DESIGN #	DRAWN BY CB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED LE	APPROVED #	DRAWING NO. D2594	REV. C SHEET 1 OF 1
DATE 06.11.20		TITLE PLUG SCALE 2:1	
REV	DATE	DESCRIPTION	
A	96.09.16	NEW ISSUE	
B	97.03.15	ADD GROOVE AND O-RING	
C	06.11.20	ADD PWDR COAT; ADD MS P/N TO D2594-3; ADD AMS SPECS; ADD TOLERANCE NOTE	

RELEASED

06.11.28

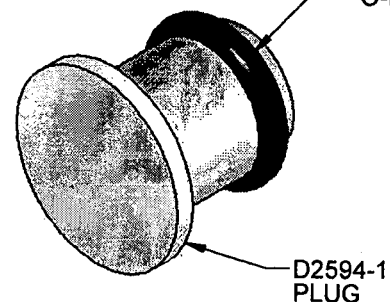
**D2594-1 PLUG****D2594-1 PLUG NOTES:**

- 1) MATERIAL: ALUMINUM 5052-H32 ROUND BAR PER QQ-A-225/7 (REF DART SPEC M5052H32R) OR ALUMINUM 6061-T6/T651/T6510/T6511/T62 ROUND BAR PER QQ-A-225/8 OR QQ-A-200/8 OR AMS 4117/4128/4115/4116/4160 (REF DART SPEC M6061T6R)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT SPECIFIED FACES WHITE GLOSS (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP EDGES TO 0.010 MAX

D2594-3 O-RING NOTES:

- 1) 5/16 ID, 7/16 OD, 1/16 WIDTH
- 2) POSSIBLE SUPPLIER P/N: PARKER 2-011 OR MS28775-011

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 74442

D2594-3
O-RINGD2594-1
PLUG**D2594 PLUG ASSEMBLY****PARTS LIST:**

QTY	P/N	DESCRIPTION
X	D2594	PLUG ASSEMBLY
1	D2594-1	PLUG
1	D2594-3	O-RING

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